

Date: Tuesday, 9/19/2006 2:11:39 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CROSSBOLT SPACER
 Job Number : 28648
 Estimate Number : 11010
 P.O. Number : *N/A*
 This Issue : 9/19/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : MACHINED PARTS
 Previous Run : 28250
 Part Number : D2649
 Drawing Number : D2649 REV B1
 Project Number : N/A
 Drawing Revision : B1
 Material : *N/A*
 Due Date : 9/30/2006 Qty: 400 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est F 02.03.26 Added turning on Cobra NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6T0375W058 6061-T6 Tube .375 x.058W



Comment: Qty.: 0.2975 f(s)/Unit Total: 118.9860 f(s)

6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch *701937*

2.0 HARDINGE HARDINGE CNC LATHE SMALL

PG



Issue P.O. 2080



cold 09/19 (400)

Comment: HARDINGE CNC LATHE SMALL

Machine as per folio on cobra machine.

turn per drawing D2649 Rev.B1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive & Inspect



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

for transit damage (Bolt) (420)

4.0 QC5 SECOND CHECK



Comment: SECOND CHECK

Inspect Levels Job 10-10 counted (417)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *S154*

LB 06/10/10

(417)

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 06/10/11

Job Completion



W 06-10-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/14

QA: N/C Closed: _____ Date: _____

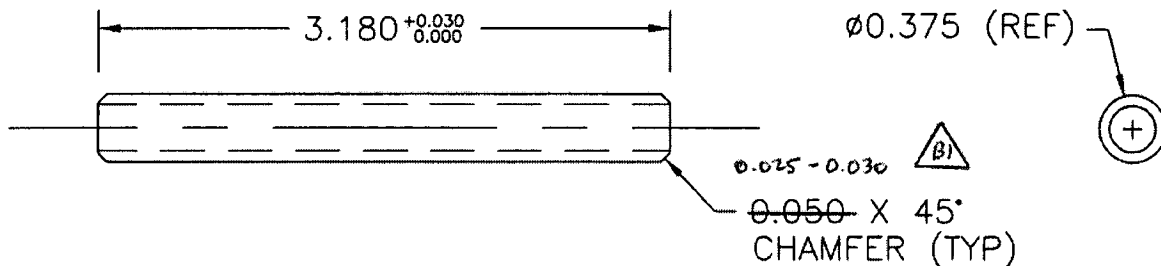
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|----------------------|---------------------------------|---|------------------------|
| DESIGN <i>DM</i> | DRAWN BY <i>KE</i> | DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA | |
| CHECKED <i>DM</i> | APPROVED <i>BW</i> | DRAWING NO. D2649 | REV. B SHEET 1 OF 1 |
| DATE 98.01.14 | | TITLE CROSS BOLT SPACER | SCALE 1:1 |
| A | 97.03.25 | NEW ISSUE | |
| B | 98.01.14 | 3.180 WAS 3.230, ADD CHAMFER | |
| B1 | # <i>CP</i> 02.06.13 | REDUCE CHAMFER PER TSR 1296. | |

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28648



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

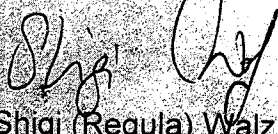
same

| <u>QUANTITY</u> | <u>PART NUMBER</u> | <u>PART NAME</u> | <u>MATERIAL BATCH NUMBER</u> | <u>P.O. NUMBER</u> |
|-----------------|--------------------|-------------------|------------------------------|--------------------|
| 417 ✓ | D2649 | Cross Bolt Spacer | M101937 | 2080 |
| 133 | D3503 | Cross Bolt Spacer | M304R100 M18429 | 2080 |

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, October 5, 2006